

Atty's 23185

Pat. App. Not known - US phase of PCT/DE2003/002845

## Amended Patent claims

1           1. (original) A method of continuously casting metal or  
2 metal alloys, especially copper or copper alloys in which the  
3 liquid metal flows from a heating vessel through a casting nozzle  
4 into the casting pool of a continuous casting apparatus which is  
5 provided with a traveling mold, characterized in that the casting  
6 nozzle is configured as an immersion tube which projects into the  
7 casting pool formed by the traveling mold sides.

1           2. (original) The method according to claim 1  
2 characterized in that the immersion tube is matched in its  
3 inclination to the position of the melt level in the casting pool  
4 and is optionally controlled by feedback in response thereto.

1           3. (currently amended) The method according to claim 1  
2 ~~or 2~~ characterized in that the transport belts are slightly  
3 inclined with respect to the horizontal, preferably between 3° and  
4 45° and/or have a spacing which is greater than 20 mm.

1           4. (currently amended) The method according to ~~one of~~  
2 ~~claims 1 to 3~~ claim 1, characterized in that the liquid molten  
3 metal is transferred from the furnace directly into the immersion  
4 tube, preferably under pressure.

1           5. (original) A casting device for the continuous  
2 horizontal casting of metal, comprised of a furnace (10), a device  
3 for transferring the liquid molten metal and a traveling mold,  
4 characterized in that the device for transferring the liquid molten  
5 metal is an immersion tube (13) which is movable along its  
6 longitudinal axis.

1           6. (original) The casting device according to claim 5  
2 characterized in that the immersion tube (13), preferably along its  
3 outer surface, has spacing sensors with which the relative position  
4 of the immersion tube to the casting pool can be adjustably  
5 controlled.

1           7. (currently amended) The casting device according to  
2 claim 5~~or 6~~ characterized in that the immersion tube is fixed  
3 directly with the casting furnace (10, 11) and that the furnace is  
4 movable along a path inclined to the horizontal so that the  
5 immersion tube (13) is displaceable by the movement of the furnace.

1           8. (currently amended) The casting device according to  
2 ~~one of claims 5 to 7~~ claim 5 characterized in that the immersion  
3 tube (13) is arranged with an inclination relative to the  
4 longitudinal axis of the casting gap and is displaceable.